



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-708-011
Job Sheet 173558



Part No: D205-708-011

Job Qty: 1 ea

Part Name: Adjustable Engine Modification



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Due Date: 3/22/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV C IPP C 06.01.31 Added MS206136C12 JLM/AP IPP Rev:D 07-12-12 as per ECN 1074 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Purchasing	2 pcs		3/22/18	0.00	0.00	Purchasing		AT 3/25/18
120	Packaging	2 pcs		3/22/18	0.00	0.00	Packaging2		AT 3/25/18
130	QC	2 pcs		3/22/18	0.00	0.00	QC5		MAY 22 2018
135	Packaging	2 pcs		3/22/18	0.00	0.00	Packaging1-2		MAY 23 2018
140	QC	2 pcs		3/22/18	0.00	0.00	QC4		DAS 58
145	DC	2 pcs		3/22/18	0.00	0.00	DC		MAY 23 2018
150	Packaging	2 pcs		3/22/18	0.00	0.00	Packaging3-1		MAY 23 2018
160	QC21-FG	2 Ea		3/22/18	0.00	0.00	QC21		MAY 23 2018

Part Op 90 - Issue P/O: P/O: 039230 for: (ATTN:ORDER THE B P/N'S! - SAME AS BOM) 6 D3284-001 (B80702-1) Sleeve
 Descriptions: 2 D3284-003 (B80703-1) Stud 4 D3284-005 (B80704-1) Stud 6 D3284-007 (B80705-1) Stud 6 NAS509-12 Nut 6
 NAS509L12 Nut Stud To be assembled as per Dwg B80701 Rev. C Possible Supplier: Northern Aero Certificate of
 Conformity is required
 120 - Receive & Inspect For Transit Damage Ensure Certificate of Conformity is attached
 130 - Inspect assembly. Visually inspect thread, fit and cad plating
 145 - Photocopy bluefile and create labels per PPP D205-708-011, CHG001
 150 - Identify and pack for shipping as per PPP D205-708-011 Location: FG028

MAR 07 2018

DAS
13
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
B80702-1	Sleeve	12 pcs (6 ea)	90-Purchasing	5072702
B80703-1	Stud	4 pcs (2 ea)	90-Purchasing	5072703
B80704-1	Stud	8 pcs (4 ea)	90-Purchasing	5072704
B80705-1	Stud	12 pcs (6 ea)	90-Purchasing	5072705
D3284-009	Bearing	12 Ea (6 ea)	90-Purchasing	5046500x2
D3284-011	Bearing	2 Ea (1 ea)	90-Purchasing	5046501
MS20613-6C12	Rivet	4 Ea (2 ea)	90-Purchasing	FM136648.0
MS20613-6C16	Rivet	16 Ea (8 ea)	90-Purchasing	F115358
MS20613-6C18	Rivet	8 Ea (4 ea)	90-Purchasing	FM125880
MS20613-6C19	Rivet	24 Ea (12 ea)	90-Purchasing	FM136837
NAS509-12	Nut	12 Ea (6 ea)	90-Purchasing	5072706
NAS509L12	Nut	12 Ea (6 ea)	90-Purchasing	5072707



Container No: S073031



Part: D205-708-011

Job No: 173558

Serial No/Batch: S073031

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/22/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	B80702-1	12	0	0
	B80703-1	4	0	0
	B80704-1	8	0	0
	B80705-1	12	0	0
	D3284-009	12	6	0
	D3284-011	2	4	0
	MS20613-6C12	4	75	0
	MS20613-6C16	16	194	0
	MS20613-6C18	8	40	0
	MS20613-6C19	24	95	0
	NAS509-12	12	62	0
	NAS509L12	12	46	0
Part Specifications				
Specifications could not be found.				

Plex 3/5/18 8:12 AM dart.lavoie.chantal

SPECIFICATION CONTROL DRAWING

	DART P/N	SPECIFICATION
6	D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
2	D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
4	D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
6	D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
6	D3284-009 BEARING	BHT P/N 47-140-252-5
1	D3284-011 BEARING	BHT P/N 205-060-101-001
	D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
	D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
	D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
	D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
	D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
	D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708

x10 5
 x4 2
 x8 4
 x10 5



NOTE:

FOR FUTURE PROCUREMENT, THE PURCHASE ORDER MUST SPECIFY THAT THE MATERIAL USED TO MANUFACTURE THE D3284-001/-003/-005/-007 PARTS MUST COMPLY WITH THE FOLLOWING SPECIFICATIONS:

AISI 4130 ROUND BAR PER AMS 6348/MIL-S-6758 WITH
 MIN Ft_u = 90 Ksi
 MIN Ft_y = 70 Ksi

EACH INDIVIDUAL ITEM TESTED BEFORE USE OR PROVEN TO EQUAL OR EXCEED THE ABOVE.

RELEASED

2010-03-25

B	ADD NOTE	RF	09.07.14
A	NEW ISSUE	KJ	04.05.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3284	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ADJUSTABLE ENGINE MOUNT	NTS
DATE	09.07.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039230

Supplier: BEA001-VU
B/E Aerospace
25 Dunlop Avenue
Winnipeg
MB
R2X 2V2 Canada
Phone: 204-772-9922
Fax: 204-772-7568

PO No: PO039230
PO Date: 3/7/18
Due Date: 3/27/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

REVISED

\$

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
MAR 08 2018

MAR 08 2018

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	B80702-1			Sleeve	Firmed	4/2/18 4/30/18	12 pcs	0 pcs 12	12 pcs	\$250.00/pcs	\$3,000.00
2	B80703-1			Stud	Firmed	3/27/18 4/30/18	4 pcs	0 pcs 4	4 pcs	\$99.00/pcs	\$396.00
3	B80704-1			Stud	Firmed	3/27/18 4/30/18	8 pcs	0 pcs 8	8 pcs	\$165.00/pcs	\$1,320.00
4	B80705-1			Stud	Firmed	6/4/18 4/30/18	12 pcs	0 pcs 12	12 pcs	\$170.00/pcs	\$2,040.00
5	NAS509-12			Nut receive ea	Firmed	3/27/18 4/30/18	12 Ea	0 Ea 12	12 Ea	\$12.00/Ea	\$144.00
6	NAS509L12			Nut receive ea	Firmed	3/27/18 4/30/18	12 Ea	0 Ea 12	12 Ea	\$12.00/Ea	\$144.00
Grand Total:											\$7,044.00

DAS
11
930

Order Notes

rev'd AT 18/05/18

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A032 PUBLIC LAW 101-592 FASTENER QUALITY ACT
A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

CL
R

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/8/18 12:33 PM dart.lavoie.chantal



Passion to Innovate.
Power to Deliver.

Page 1 of 1

Certificate of Compliance

Customer: Dart Aerospace Ltd.
Customer Order Number: P0039230
Sales Order Number: 39513-1

Part Number: B80702-1	Description: Sleeve, Engine Mount
Drawing / Revision Level: A	Quantity: 12
Production Order: PR1800025612	Batch No.: PR1800025612
Part Number: B80703-1	Description: Stud, Male 7/8, Engine Mount
Drawing / Revision Level: A	Quantity: 4
Production Order: PR1800025612	Batch No.: 14-3187
Part Number: B80704-1	Description: Stud, Male, 3/4, Engine Mount
Drawing / Revision Level: A	Quantity: 8
Production Order: PR1400016026	Batch No.: 14-3186
Part Number: B80705-1	Description: Stud, Female, Engine Mount
Drawing / Revision Level: B	Quantity: 12
Production Order: PR1800025613	Batch No.: PR1800025613

B/E Aerospace Limited hereby certifies that materials, work performed and quality meet the requirements stated on the Customer's Purchase Order(s) and/or drawing(s).

Notes / Comments:

Condition - NEW

Signature:

Name: Jeff Brien

Date: 2018 Apr 27

Form completed by: Jean Martin

DAS
11
9-89

MAY 22 2018



Passion to Innovate.
Power to Deliver.

Page 1 of 1

Certificate of Compliance

Customer: Dart Aerospace Ltd.

Customer Order Number: P0039230

Sales Order Number: 39513-1A

Part Number: B80702-1	Description: Sleeve, Engine Mount
Drawing / Revision Level: A	Quantity: 12
Production Order: PR1800025612	Batch No.: PR1800025612
Part Number: B80703-1	Description: Stud, Male 7/8, Engine Mount
Drawing / Revision Level: A	Quantity: 4
Production Order: PR1400016025	Batch No.: 14-3187
Part Number: B80704-1	Description: Stud, Male, 3/4, Engine Mount
Drawing / Revision Level: A	Quantity: 8
Production Order: PR1400016026	Batch No.: 14-3186
Part Number: B80705-1	Description: Stud, Female, Engine Mount
Drawing / Revision Level: B	Quantity: 12
Production Order: PR1800025613	Batch No.: PR1800025613

B/E Aerospace Limited hereby certifies that materials, work performed and quality meet the requirements stated on the Customer's Purchase Order(s) and/or drawing(s).

Notes / Comments:

DAS
11
9-89

Condition - NEW

This corrected certificate replaces the certificate 39513-1 dated 2018 Apr 27 and does not recertify conformity / condition or release to service.

Signature: Marcie Hayag
Name: Marcie Hayag Date: 2018 May 17

MAY 22 2018

Form completed by: Jean Martin



Passion to Innovate.
Power to Deliver.

B/E Aerospace Limited

25 Dunlop Avenue
R2X 2V2 Winnipeg
Canada
Tel : 204-783-5402
Fax : 204-783-5436

Packing Slip

Delivery No. : 8479
Delivery Date : 2018-04-26
SO No. : 39513
Your Reference : PO: PO039230
Delivery Method : FEDEX
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: CHANTAL LAVOIE
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Item	Description Batch Number	Total		Qty	Delivery Date
		Ordered	Unit	Delivered	
B80702-1	SLEEVE, ENGINE MOUNT PR1800025612	12	EA	12	2018-04-26
B80703-1	STUD, MALE, 7/8, ENGINE MOUNT 14-3187	4	EA	4	2018-04-26
B80704-1	STUD, MALE, 3/4, ENGINE MOUNT 14-3186	8	EA	8	2018-04-26
B80705-1	STUD, FEMALE, ENGINE MOUNT PR1800025613	12	EA	12	2018-04-26
NAS509-12	NUT (.7500-16 UNJF-3B) 13-1954	12	EA	12	2018-04-26
NAS509-L12	NUT STEEL (.7500-16 UNJF-3B-LH) LH THREAD 13-2349	12	EA	12	2018-04-26

MAY 22 2018

DAS
11
2-89

Ordered by: Dart Aerospace Ltd.

Attention: CHANTAL LAVOIE
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Invoice to: Dart Aerospace Ltd.

Attention: Accounts
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Remarks

Certification Statement

I hereby certify that the aircraft part(s) described hereon were acquired from a source of supply that is consistent with the conditions under which TCCA distributor approval AMO88-97 has been granted.

Signatory

Date:

27 APR 2018

4.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D205-708-011	ADJUSTABLE ENGINE MOUNT KIT (205/UH-1)
	X	D204-708-013	ADJUSTABLE ENGINE MOUNT KIT (204)
6	6	D3284-001	SLEEVE
2		D3284-003	STUD
4	6	D3284-005	STUD
6	6	D3284-007	STUD
6	6	D3284-009	BEARING
1	1	D3284-011	BEARING
2	2	MS20613-6C12	RIVET
8	12	MS20613-6C16	RIVET
8		MS20613-6C18	RIVET
8	12	MS20613-6C19	RIVET
6	6	NAS509-12	NUT
6	6	NAS509L12	NUT

5.0 WEIGHT AND BALANCE

The following is the net weight and moment change associated with this installation

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-708-011 Adjustable Engine Mount Kit (205/UH-1)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	188.5 in 4.79 m	1810 lb-in 21.1 kg-m
D204-708-013 Adjustable Engine Mount Kit (204)	9.6 lb 4.4 kg	-3.0 in -0.08 m	-28.8 lb-in -0.35 kg-m	184.5 in 4.69 m	1771 lb-in 20.6 kg-m